



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5124-1

Job Sheet 174944



Part No: D5124-1

Job Qty: 10 ea

Part Name: Fwd Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 5/4/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP rev A RQ verified by JLM 14/08/08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		5/3/18	0.00	0.00	Start Up Machining-3		
100	CNC Vertical Machining	10 pcs		5/4/18	0.37	15.38	HAAS1-4		
110	QC	10 pcs		5/4/18	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs		5/4/18	0.00	0.00	QC8 Machining-3		
130	Packaging	10 pcs		5/4/18	0.00	0.00	Packaging3-2	LG054	18-06-17
140	QC21-SA	10 Ea		5/4/18	0.00	0.00	QC21		18-6-17

Part Op 100 - Machine as per Folio FB340
Descriptions: 130 - LOCATION : LG054

DAS
21
9-89
18-06-18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5124-1TRN	Support	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5124-1TRN	5	2	0

5079976 → 3x

F162305 → 1x

F165605 → 1x



Container No: S081276



Part: D5124-1

Job No: 174944

Serial No/Batch: 000 270

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/14/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Support	2.028Inches $\pm$ 0.030	2.058 1.998		
2	Fwd Support	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
3	Fwd Support	0.188Inches + 0.005 - 0.001	0.193 0.187		
4	Fwd Support	0.257Inches + 0.006 - 0.001	0.263 0.256		
5	Fwd Support	3.150Inches $\pm$ 0.010	3.160 3.140		
6	Fwd Support	0.276Inches $\pm$ 0.010	0.286 0.266		
7	Fwd Support	0.410Inches $\pm$ 0.030	0.440 0.380		
8	Fwd Support	3.100Inches $\pm$ 0.010	3.110 3.090		
9	Fwd Support	1.472Inches $\pm$ 0.010	1.482 1.462		
10	Fwd Support	2.796Inches $\pm$ 0.010	2.806 2.786		
11	Fwd Support	0.230Inches $\pm$ 0.030	0.260 0.200		
12	Fwd Support	1.109Inches $\pm$ 0.010	1.119 1.099		
13	Fwd Support	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	

Plex 3/23/18 10:25 AM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	174944
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.018	2.038		2.025	2.028	2.028	2.029	2.029
AB	R0.28	R0.28		0.250	R.250	R.250	R.250	R.250
AC	0.187	0.193		0.188	.189 ϕ	.189 ϕ	.189 ϕ	.189 ϕ
AD	0.256	0.262		0.257	.256 ϕ	.256 ϕ	.256 ϕ	.256 ϕ
AE	3.140	3.160		3.156	3.155	3.156	3.155	3.154
AF	0.266	0.286		0.276	.276	.276	.276	.276
AG	0.38	0.440		0.414	.414	.414	.412	.415
AH	3.090	3.110		3.100	3.100	3.100	3.100	3.094
AI	1.462	1.482		1.4715	1.471	1.470	1.472	1.470
AJ	2.786	2.806		2.802	2.799	2.799	2.799	2.799
AK	0.200	0.260		0.260	.260	.260	.260	.260
AL	1.099	1.119		1.115	1.115	1.115	1.115	1.117
AM	R0.220	R0.280		0.250	R.250	R.250	R.250	R.250
AN								
AO								
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that $\emptyset$ " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:	M.N.	Checked by:	20 8-88	QC Inspector:	
Date:	2018/06/14	Date:	18-06-17	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	61	72	83	94	105
HAAS Section								
AA				2.029	2.029	2.029	2.029	2.029
AB				R.250	R.250	R.250	R.250	R.250
AC				.189	.189	.189	.189	.189
AD				.256	.256	.256	.256	.256
AE				3.154	3.155	3.155	3.154	3.155
AF				.276	.276	.276	.277	.277
AG				.416	.416	.417	.416	.416
AH				3.099	3.098	3.098	3.099	3.099
AI				1.471	1.471	1.470	1.468	1.467
AJ				2.799	2.799	2.800	2.799	2.799
AK				.260	.260	.260	.260	.260
AL				1.116	1.118	1.118	1.117	1.117
AM				R.250	R.250	R.250	R.250	R.250
AN								
AO								
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:	M.M.	Checked by:	DAS 20 9-89	QC Inspector:	
Date:	2018/06/14	Date:	18-06-17	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
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